

Unit 5

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Introduction

Tobacco is a plant whose leaves are used for the production of cigarettes and cigars. It is a fastidious plant that requires a proper soil and a moderate climate. It is an annual plant which means that it has only one crop a year. In countries where tobacco plants flourish, the temperature does not fall below 45 degrees Fahrenheit. It is grown in countries with a tropical or semi-tropical climate such as India, Cuba, Sumatra, Java, Jamaica and the Philippines. The leading producers of tobacco are China, India, Brazil, Russia and the United States. In their original home in the USA, tobacco leaves acquire characteristics that are accepted internationally and are popular. The time span from planting to shipment is about two years.



It is believed that Native Americans were the first to discover tobacco. In 1492, Christopher Columbus found that they smoked it in pipes. Columbus brought the tobacco seeds to Europe where farmers grew them for medicinal purpose to relax the body. In 1560, a French diplomat Jean Nicot from whose name comes the botanical name *Nicotiana* and the term *nicotine*, introduced its use in France, France and Spain started smoking hand-rolled cigarettes in 1600.

Cultivation and Processing of Tobacco

Planting: The seeds are planted in nurseries and are carefully taken care of till the young plants are strong enough to be transplanted. Once it has grown the flower buds are removed to get bigger and juicier leaf. A constant eye has to be kept on them especially against pests. The dead stems are removed regularly. The plants ripen in about 6 months with the leaves turning yellowish green.

Harvesting: It is normally on a cloudy day as a precaution against a disease known as sunburn. The selected plants are the ripest and are cut close to the root and then laid gently in rows in the field where they are left to wilt before being taken away to be dried and cured.

Curing: It is necessary to cure tobacco after harvesting and before it can be consumed. Tobacco curing is also known as **color curing**, because tobacco leaves are cured with the intention of changing their color and reducing their chlorophyll content. Curing tobacco has always been a process necessary to prepare the leaf for consumption because, in its raw, freshly picked state, the green tobacco leaf is too wet to ignite and be smoked.



- **Air-cured** tobacco is hung in well-ventilated barns and allowed to dry over a period of four to eight weeks. Air-cured tobacco is low in sugar, which gives the tobacco smoke a light, sweet flavor, and high nicotine content. Cigar and burley tobaccos are air cured.
- **Fire-cured** tobacco is hung in large barns where fires of hardwoods are kept on continuous or intermittent low smoulder. Fire curing produces a tobacco low in sugar and high in nicotine. Pipe tobacco, chewing tobacco, and snuff are fire cured.
- **Flue-cured** tobacco was originally strung onto tobacco sticks, which were hung from tier-poles in curing barns. These barns have flues which run from externally fed fire boxes, heat-curing the tobacco without exposing it to smoke, slowly raising the temperature over the course of the curing. The process will generally take about a week. This method produces tobacco that is high in sugar and has medium to high levels of nicotine.
- **Sun-cured** tobacco dries uncovered in the sun. Sun-cured tobacco is high in sugar and low in nicotine. In India sun curing is used to produce so-called "white" snuffs, which are fine, dry, and unusually potent.

After fermentation/ curing the leaves become pliable and attain flavour. The leaves are then removed from the mid ribs and sorted out according to quality / perfection.

The leaves for pipe tobacco and cigarettes are shredded through machine. The shredding is finer for cigarettes compared to pipe tobacco. For cigars the tobacco leaves are sorted out in a different way. The best quality or the perfect leaves are used for the outside wrapper. The slightly imperfect leaves are used for the binder. Whereas the broken or imperfect leaves are used for the filler.

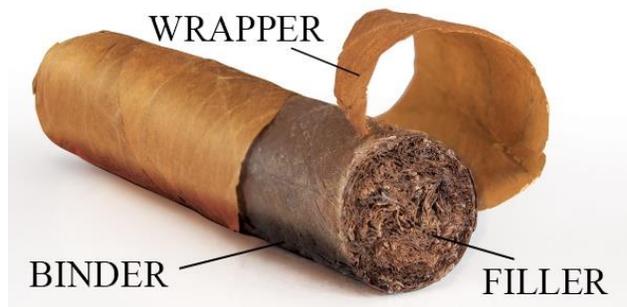
Cigar

A cigar is a rolled bundle of dried and fermented tobacco leaves. They are produced in a wide variety of sizes and shapes. Since the 20th century, almost all cigars are made of three distinct components: the filler, the binder leaf which holds the filler together, and a wrapper leaf, which is often the best leaf used. Often there will be a cigar band printed with the cigar manufacturer's logo.

- **Filler:** It forms the interior core of the cigar and it makes most of the cigar. Tobacco leaves used as fillers can be either long or short. Long fillers are made up of whole leaves which are of better quality, while the shorter ones are made of chopped leaves, which are inferior. Filler is made of a blend of leaves of different regions to get good flavor.
- **Binder:** It is a good quality leaves with high tensile strength which holds the filler. Two to four leaves of filler tobacco are laid end to end and rolled into the binder leaves.
- **Wrapper:** It is the outside of cigar and also the most expensive part. A whole leaf of the finest quality is chosen and it must be elastic, smooth, of a good colour and not too prominently veined. It should also have a good aroma since it is the most vital ingredient in the taste of cigar. The bunch is laid at an angle across the strip of wrapper leaf. The wrapper leaf is wrapped carefully around the binder, overlapping at each turn till the end of the hook and is stick with vegetable gum, forming the rounded closed head. It is then cut at the end to the length required.

Classification of cigars based on wrapper colors

The cigar wrapper is its outermost leaf. It is responsible for almost every aspect of the cigar starting with the looks and ending with the flavor. A good wrapper is basically the "preview" of the cigar and is responsible for its appearance. Following are the various terms used to denote wrapper colors used in cigar making.



- | | |
|--------------------------|---------------------|
| • Double Claro | greenish brown |
| • Claro | light, golden brown |
| • Colorado Claro | medium brown |
| • Colorado | reddish mid-brown |
| • Colorado Maduro | dark brown |
| • Maduro | very dark brown |
| • Oscuro | black |



Classification of cigar based on sizes: Cigars are measured by two factors: length, which is given in inches, and "ring gauge," a designation of a cigar's diameter broken into 64ths of an inch. A cigar with a 42 ring gauge, for example, is 42/64 of an inch in diameter.

| Size | Length | Ring |
|-------------------|--------------|------|
| Belicoso | 5 1/2 inches | 52 |
| Churchill | 7 inches | 47 |
| Corona | 5 1/2 inches | 44 |
| Corona Gorda | 5 1/4 inches | 46 |
| Culebras | 5 3/4 inches | 39 |
| Demi Tasse | 4 inches | 30 |
| Double Corona | 7 1/2 inches | 49 |
| Especial | 7 1/2 inches | 38 |
| Gran Corona | 9 1/4 inches | 47 |
| Hermoso | 5 inches | 48 |
| Long Panetela | 7 inches | 36 |
| Lonsdale | 6 1/2 inches | 42 |
| PanetalaPerta | 4 1/2 inches | 26 |
| Petit Corona | 4 inches | 40 |
| Pyramid/Torpedo | 5 inches | 42 |
| Robusto | 5 inches | 50 |
| Rothschild | 5 inches | 50 |
| Tres Petit Corona | 4 1/2 inches | 40 |

Classification cigar based on shapes: According to the shape, cigars are classified into two groups

- **Parejo:** This is the common shape which has cylindrical body, straight sides, one end open, and a round tobacco - leaf cap on the other end.
- **Figurado:** These cigars come in irregular shapes. The common shapes of Figurado are torpedo, pyramid, perfecto and tuscanian.

PAREJO



FIGURADO



Brands of Cigars

Bolivar, Romeo, Romeo-Y-Julieta, Upman, La Corona , Bock, Havana, Henry Clay, Oscar, Davidoff, Dunhill, Casa Blanca.

Storage of Cigar

A fine cigar should be kept at between 15°C and 18°C (60 °F and 65 °F) and between 55 percent and 60 per cent relative humidity, with as little variation as possible. A cigar will pick up any smell or moisture in the air, or dry up and smoke like tinder.

Cigars are stored in humidor boxes. These boxes are made of cedar wood. A humidor's primary function is to maintain a steady, desirable moisture level inside; secondarily it protects its contents from physical damage and deterioration from sunlight. Humidors come in all shapes and sizes and can be as small as a box to use as a travel humidor or as large as a walk-in closet, mostly used in hotels. Regardless of the size, each humidor will have a good seal to maintain the internal temperature and provide a thermostat and hygrometer to maintain optimal conditions.



Service of Cigar: The following steps are followed in cigar service.

- Present the humidor from the left-hand side of the guest to select cigar.
- Remove the selected cigar carefully making sure your finger nail does not touch the wrapper of any of the cigars.
- Collect the cigar from the guest for preparation. Ask the guest if the band of the cigar maybe removed and what type of cut he prefers, straight or V-cut before taking it to the sideboard.
- Take the cigar to the sideboard to prepare according to the guest's request.
- On the sideboard, if the cigar is covered with cellophane, tear the tab and carefully remove the cigar by applying gentle pressure at the end of the cellophane tube. Place the cellophane in the pocket.
- If the guest wants the band to be removed, gently apply pressure below the band and remove it without damaging the wrapper.
- Open the closed end of the cigar by making a flat or V-cut with appropriate cigar cutter. Avoid piercing it with matchstick or spike.
- Tap the cut cigar over the side plate to remove any unwanted /extra tiny particles.
- Present the prepared cigar on a quarter plate from the left hand side.
- Assist the guest in lighting cigar



If the band is not removed before lightning the cigar, the guest will remove it during the course of smoking. Removal of band is easier after smoking for a while, as the cigar has warmed up a little and shrunk.

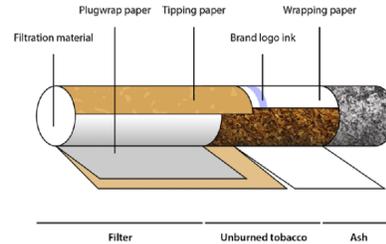
Cigarette

A cigarette is a small cylinder of finely cut tobacco leaves rolled in thin paper for smoking. The cigarette is ignited at one end and allowed to smoulder; its smoke is inhaled from the other end.

Most modern manufactured cigarettes are filtered and include reconstituted tobacco and other additives.

Manufacturing of Cigarette

- Paper:** The paper for holding the tobacco blend may vary in porosity to allow ventilation of the burning ember or contain materials that control the burning rate of the cigarette and stability of the produced ash. The papers used in tipping the cigarette (forming the mouthpiece) and surrounding the filter stabilize the mouthpiece from saliva and moderate the burning of the cigarette, as well as the delivery of smoke with the presence of one or two rows of small laser-drilled air holes
- Tobacco blend:** The tobacco grown in different parts of a country are carefully blended to produce a well-balanced tobacco blend, which can be filled into cigarette wrappers. The tobacco blend is made mainly from the leaves of flue-cured bright leaf, burley tobacco, and oriental tobacco.
- Butt:** The common name for the remains of a cigarette after smoking is a cigarette butt. The butt is typically about 30% of the cigarette's original length. It consists of a tissue tube which holds a filter and some remains of tobacco mixed with ash



Brand names of cigarette

Marlboro, 555, Benson and Hedges, Rothmans, Vogue, Parliament, Kent, Gold Flake, Davidoff, Four Square, American Club, Navy Cut, Bristol, Berkeley and Duke and Royal.

Sizes of Cigarettes: In general, cigarettes length is measured in millimeter (mm). Common sizes of cigarettes are well explained below with the help of a picture.

Cigarette Size Chart



Service of cigarette

Cigarettes should never be carried out by hand to the customer, but should be placed on a side plate with a doily paper. The packet should open and a few cigarettes should be partially pulled out. The waiter should stand by with a match box to light the cigarette. It should be made sure that the ashtray is on the table. The ashtray should never be allowed to collect too much ash; it is a waiter's duty to exchange them frequently for fresh ones.

Pipe Tobacco

Pipe Tobacco is one of the oldest ways of smoking tobacco. The tobacco is smoked in pipes. Native American cultures have pipe-smoking traditions. It has been their culture of celebrating joy and happiness long before the arrival of Europeans. Its manufacturing process is explained below.



Harvesting: The tobacco saplings are planted into well drained soil and carefully grown. The leaves ripen at various stages. The pipe tobacco leaves are usually harvested by hand from the bottom up, as each leaf ripens over a period of 4-5 weeks. In general, Virginia, burley and oriental tobaccos are used in manufacturing of tobacco.

Curing: After harvesting, tobacco leaves are dried in controlled environments to lower moisture levels, enhance the color and ensure full development of natural tobacco aromas. There are four main curing methods – Sun, Air, Fire and Flue.

Flavouring / Casing: It is the process of adding a water-based favoring early in the making of pipe tobacco. Casing influences flavour more than the aroma and in many cases; this process is used to sweeten sour tobacco or to reduce the sharpness of a specific leaf. Many flavour variants such as menthol, peppermint, chocolate can be added. Prior to the casing, the leaves are moisturized and de-stemmed.

Blending: Many blends are created by mixing various types of tobacco. Most famous blends are Dutch, English, Scandinavian and American blends.

- Dutch blend: The blend has a very pure tobacco flavor. It is dry and harsh and comes from dark-fired Virginia tobacco. Sometimes the blend includes a minor amount of pipe tobacco cuts. It is spicy in nature.
- English blend: The blend is full-bodied, moist and contains spice tobacco. At times, it has fruit and/ or flower flavouring. It is spicy in nature.
- Scandinavian blend: The blend is mellow to medium-bodied. It is flavoured with liqueur, fruits, vanilla and/ or many other flavors. Occasionally, spice tobaccos are added. The flavour characteristics are spicy, sweet, fruity, and liqueur.
- American blend: This blend is mellow and very much moist. It is flavoured with vanilla, nougat, cherry and occasionally other flavours. The flavor characteristics are sweet, fruity, and liqueur.

Cutting: The blended pipe tobacco is processed into various cuts such as flake, ready rubbed, ribbon cut, shag and plug or cake cuts.

Packaging: The pipe tobacco is packed in pouches or tins to preserve the freshness and moisture.

Pipe Tobacco Brands

